









Work Order ID 73571

Tuesday, September 06, 2011 8:42:39 AM

Item ID: D2521	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bearpaw 205				
Start Date: 9/6/2011	Start Qty: 16.00		Cust Item ID:	
Required Date: 9/16/2011	Req'd Qty: 16.00		Customer:	
Reference:				


Approvals:	Process Plan: <u>CL</u>	Date: <u>11/09/06</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2521	Rev J								


120		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	Cut Blank as per D2521 blank file							

B11-10-03

16

130		HAAS CNC VERTICAL MACHINING #1	0.00						
	HAAS 1	Memo	0.00						
	HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 3-Deburr							

DA/EK 11/10/20

140		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								

DA/EK 11/10/20

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73571

Tuesday, September 06, 2011 8:42:39 AM



Page 2

Item ID: D2521

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 205

Start Date: 9/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC8- Inspect parts - second check 0.00

0.00



QC

Memo

0.00

Quality Control

mf 11/10/26

16

4

160 Identify as per dwg & Stock Location: _____ 0.00

0.00



Packaging

Memo

0.00

Packaging

PP 71982

11/10/26 (16)

170 QC21- Final Inspection - Work Order Release 0.00

0.00



QC

Memo

0.00

Quality Control

11/10/27

mf 11-10-26

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Picklist Print

Tuesday, September 06, 2011 8:42:36 AM

Page 1

Work Order ID: 73571

Parent Item: D2521

Parent Item Name: Bearpaw 205



Start Date: 9/6/2011

Start Qty: 16.00

Required Date: 9/16/2011

Required Qty: 16.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

414.2200

7.36

117.8947

110.



UHMW 1" Black



B11-10-03

(16)

Location

Loc Qty

Loc Code

MAT018

414.22

117321

76.6

117738

124.3

117819

129.9

118257

83.42

$118814 \times 6 = 46.2$
 $118257 \times 4 = 29.5$
 $\times 6 = 46.2$
110.00

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DART AEROSPACE LTD		Work Order:	73571
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓		Vern FK-04	
B	0.90	0.96	0.930	✓		FK-06	Depth gauge.
C	0.27	0.330	0.312	✓		Vern FK-04	
D	0.470	0.530	0.530	✓		Vern FK-04	
E	21.740	21.760	21.750	✓		FK-05	Tape
F	0.72	0.780	0.751	✓		FK-04	Vern.
G	0.35	0.410	0.376	✓		"	"
H	11.490	11.570	11.500	✓		FK-05	Tape
I	3.41	3.47	3.431	✓		FK-04	Vern.
J	11.790	11.810	11.800	✓		FK-05	Tape
K	9.47	9.53	9.500	✓		"	"
L	7.190	7.210	7.200	✓		"	"
M	6.910	6.970	6.94	✓		"	"
N	44.47	44.530	44.50	✓		"	"
O	6.590	6.650	6.625	✓		CNC-02	Vern.
P	0.940	0.980	0.960	✓		FK-04	Vern.
Q	18.97	19.03	19.00	✓		FK-05	Tape
R	0.350	0.410	0.38	✓		FK-04	Vern.
S	0.740	0.780	0.760	✓		"	"
T	0.240	0.280	0.260	✓		"	"
U	0.370	0.410	0.390	✓		"	"
V	0.740	0.780	0.760	✓		"	"
W	0.740	0.780	0.760	✓		"	"

Measured by: F.K./D.A.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/19/20	Date: 11/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM [Signature]	[Signature]

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

CL11109/06
W10: 73571

RELEASED
06 08.23 #

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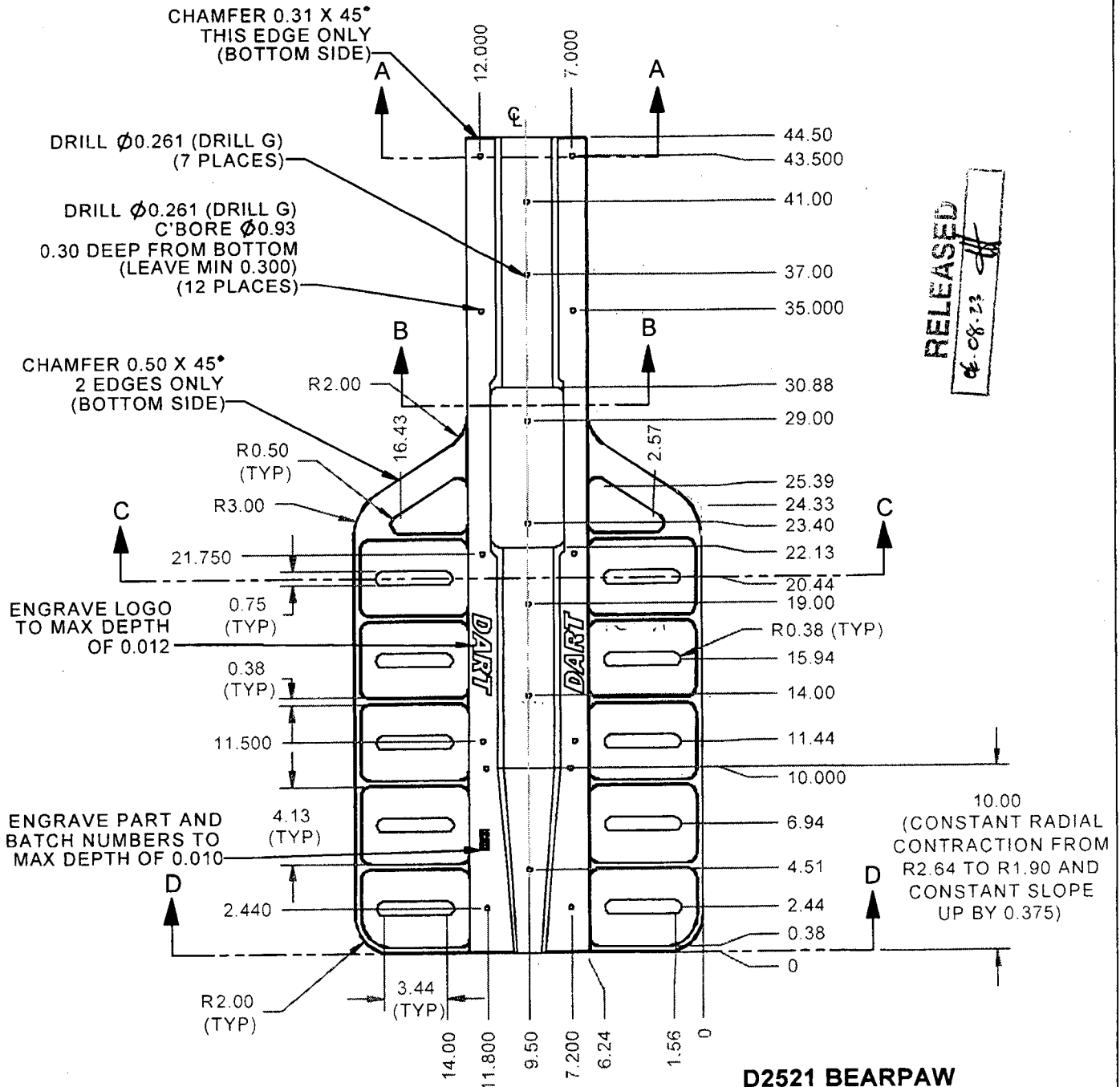
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
UP		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT ϕ

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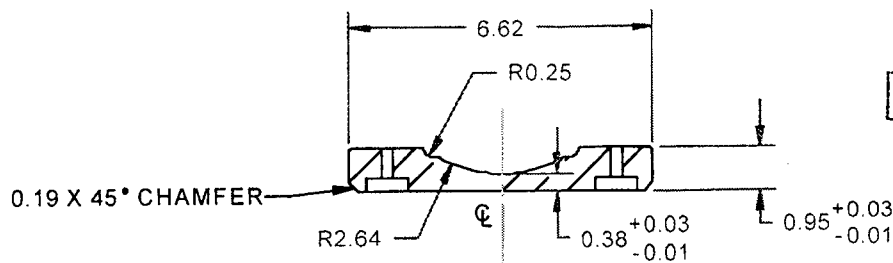
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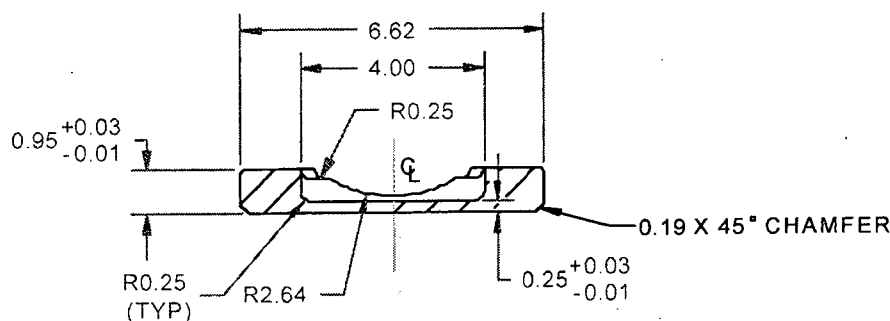
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DART

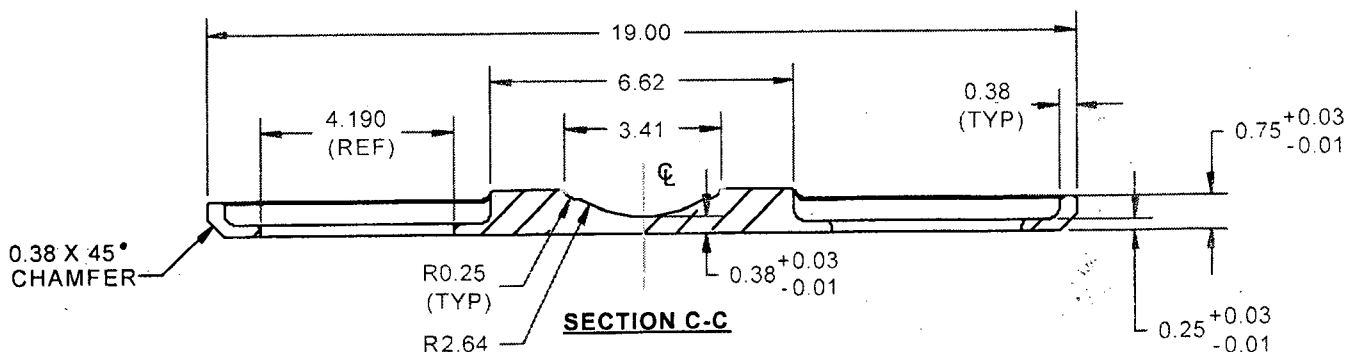
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



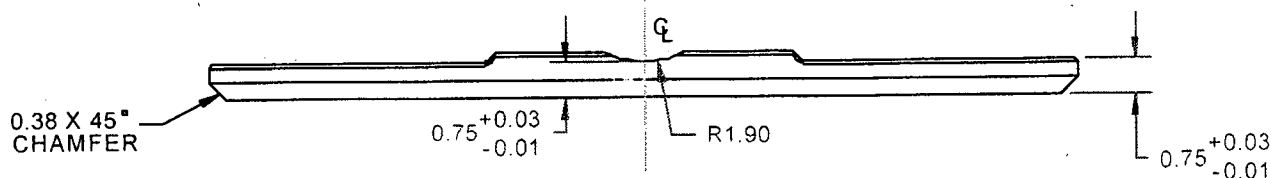
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RELEASED

06.08.23 #

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